

Work Order ID 68236

Monday, April 11, 2011 7:56:16 AM



Page 1

Item ID: D4151-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Upper Hardpoint Plate

Start Date: 4/11/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/13/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 4-11-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4151

C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D4151

Prog Rev:

Dwg Rev:

304.125

Deburr as required

1311-4-11

(10)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1311-4-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68236

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Page 2

Item ID: D4151-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Upper Hardpoint Plate

Start Date: 4/11/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/13/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

8/4/12

410

Quality Control

150

Identify as per dwg & Stock Location: 134

0.00



Packaging

Memo

0.00

11/4/12 S 102

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/4/13 J

Quality Control

B/11-04-13
10

W/O:		WORK ORDER CHANGES						
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Picklist Print

Monday, April 11, 2011 7:56:24 AM

Page 1

Work Order ID: 68236



Parent Item: D4151-3



Parent Item Name: Upper Hardpoint Plate



Start Date: 4/11/2011

Required Date: 4/13/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC□
IPP Rev:B 11.01.21 as per dwg revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	15.5000	0.055	0.578947	5.		
										 B11-3-11			

Location

Loc Qty

Loc Code

MAT020

15.5

116623

15.5

116623

(10)

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

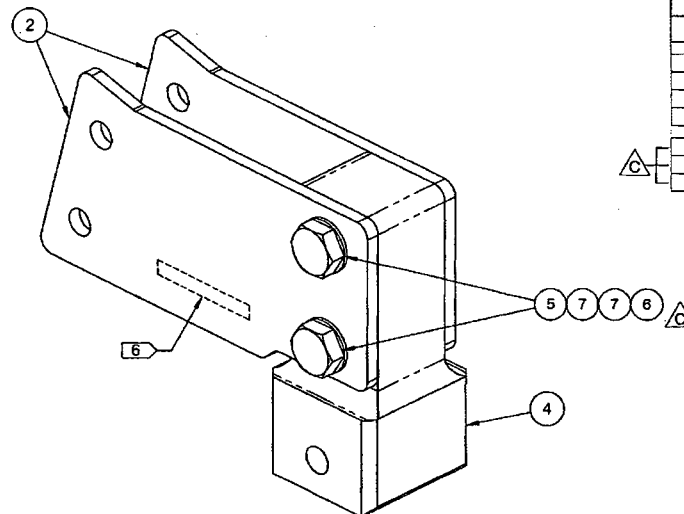
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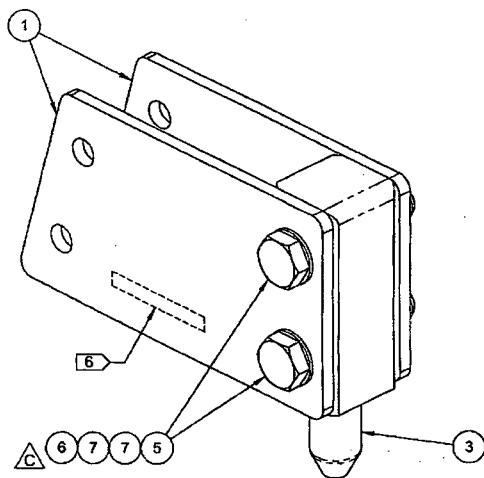
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NOTE: Date & initial all entries



D4151-043 BASKET FWD HARDPOINT ASSY (UPPER)



D4151-041 BASKET FWD HARDPOINT ASSY (LOWER)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4151-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
 - D4151-041 = 0.88 lbs
 - D4151-043 = 1.17 lbs

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
		X	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
1	2		D4151-1	LOWER HARDPOINT PLATE
2		2	D4151-3	UPPER HARDPOINT PLATE
3	1		D4151-5	FWD BASKET INSTL STUD (LOWER)
4		1	D4151-7	FWD EYEBOLT RECEIVER (UPPER)
5	2	2	AN4C13A	BOLT
6	2	2	MS21043-4	NUT
7	4	4	NAS1149C0432R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68236

11-09-09

RELEASED
2011-01-18

C	AN4 HARDWARE WAS AN3 (B6-1, C3-1 & D3-1); $\phi 0.252$ WAS $\phi 0.191$ (C5-2, D1-2); TIGHTENED TOL ON 1.000 DIM (C5-2, D1-2, C7-3, C3-3); $\phi 0.250$ WAS $\phi 0.191$ (C6-3, B4-3); 1.83 WAS 1.75 (C1-2); 2.84 WAS 2.78 (B3-3) AND 1.88 WAS 1.80 (C1-3) TO PRESERVE 1 SED. REASON: SEE D407-797 DESIGN JOURNAL.	MB	10.12.14
B	ADDED D4151-5/7 (SHT 3); D4151-5 WAS D3911-1 (ZN B6-1 & D3-1); D4151-7 WAS D3911-3 (ZN C4-1 & D3-1) ITEMS #5, 6 & 7 REPLACE MS20815-4M20 (ZN C3-1, D3-1 & B8-1); $\phi 0.191$ 2 PL REPLACES $\phi 0.129$ 3 PL (ZN C5-2); $\phi 0.191$ 2 PL REPLACES $\phi 0.129$ 4 PL (ZN D1-2); REASON: SEE TR-0350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	SC		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.14		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4151** REV. C
SHEET 1 OF 3
TITLE **BASKET FWD HARDPOINT** SCALE NTS

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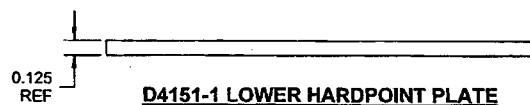
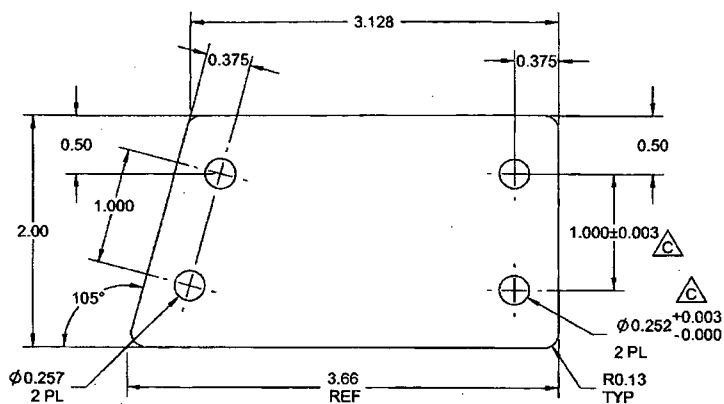
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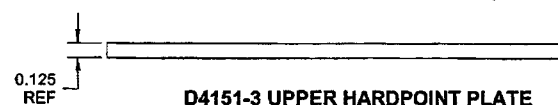
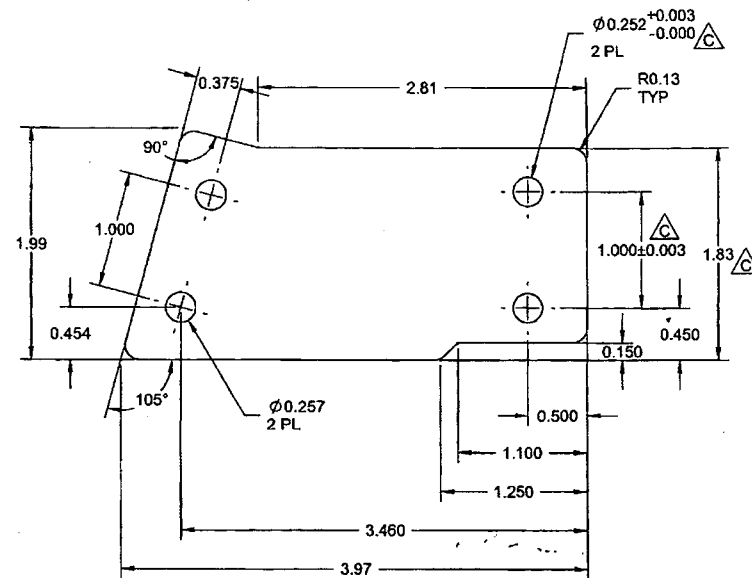
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D4151-1 LOWER HARDPOINT PLATE



D4151-3 UPPER HARDPOINT PLATE

NOTES:

1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S11GA OR M303S11GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY AT ASSEMBLY

7) WEIGHT:

- D4151-1 = 0.24 lbs

- D4151-3 = 0.23 lbs

WLO 68236

RELEASED
2011-01-18
MP

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	SC	D4151	SHEET 2 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	BASKET FWD HARDPOINT	NTS
DATE	10.12.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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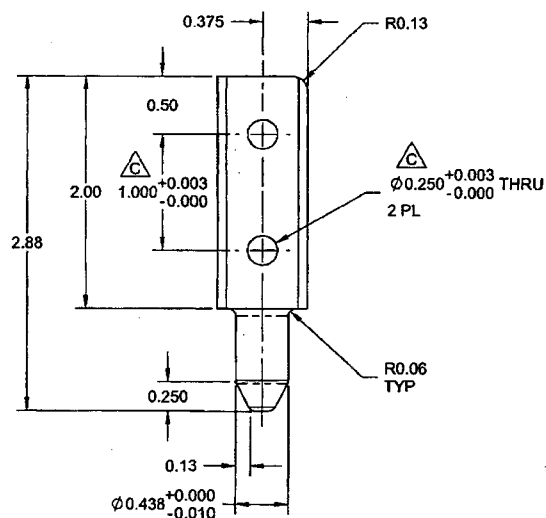
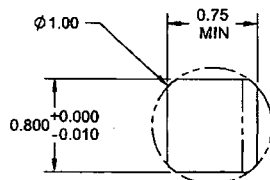
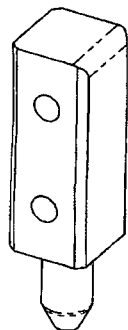
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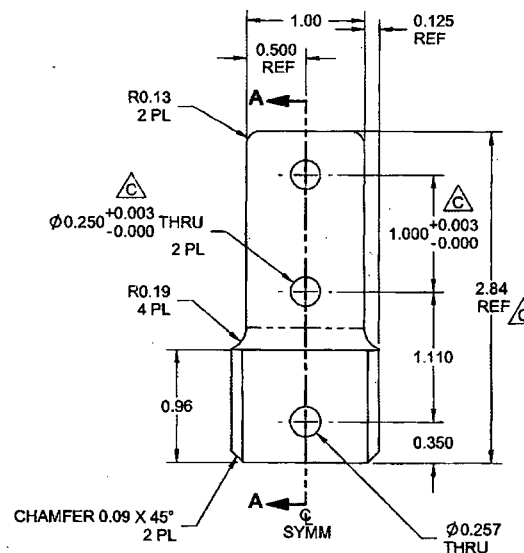
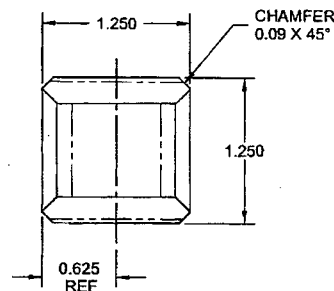
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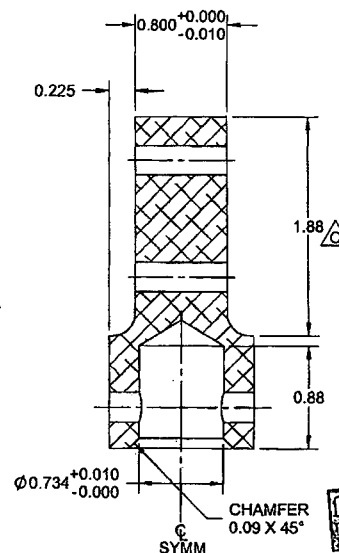
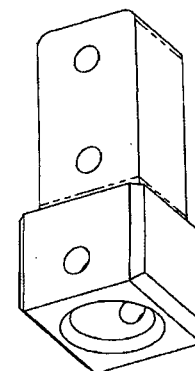


D4151-5 FWD BASKET INSTL STUD (LOWER)



D4151-7 FWD EYEBOLT RECEIVER (UPPER)

W6 48234



SECTION A-A

RELEASED
R 2011-01-30
RELEASED

NOTES:

- 1) MATERIAL -5: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582 PER DART SPEC M303R OR M304R
- 7: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582 PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -5: 0.36 lbs
- 7: 0.70 lbs

DESIGN	JL	DART AEROSPACE LTD	
DRAWN	JL	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.		D4151	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET FWD HARDPOINT	NTS
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